

Date: Tuesday, 3/20/2007 1:51:41 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FWD X-TUBE	
Job Number	: 31367				
Estimate Number	: 10006				
P.O. Number	: N/A		Part Number	: D2889	
This Issue	: 3/20/2007 S.O. No. : N/A		Drawing Number	: D2889 REV B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: 31366		Material	: N/A	
Written By			Due Date	: 4/10/2007 Qty: 1 Um: Each	
Checked & Approved By					
Comment	: Est Rev.A New Issue 05-10-25 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6005180	Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube material

Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	AS673

EL 7-3-27

2.0	BENDING	BENDING MACHINE
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Comment: LANDING GEAR RESOURCE 1

1-Bend D2889 as per Dwg D2889 and Folio FT001

EL 7-3-27

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

N/A

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

20703.20 ①

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1  
Inside and outside of tube

N/A

See Attached  
dim sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 20 Date: 07/03/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:51:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 31367

Part Number: D2889

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

5th Attached  
dm sheet

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

3/21/03 29

Job Completion



J 3/21/03 29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

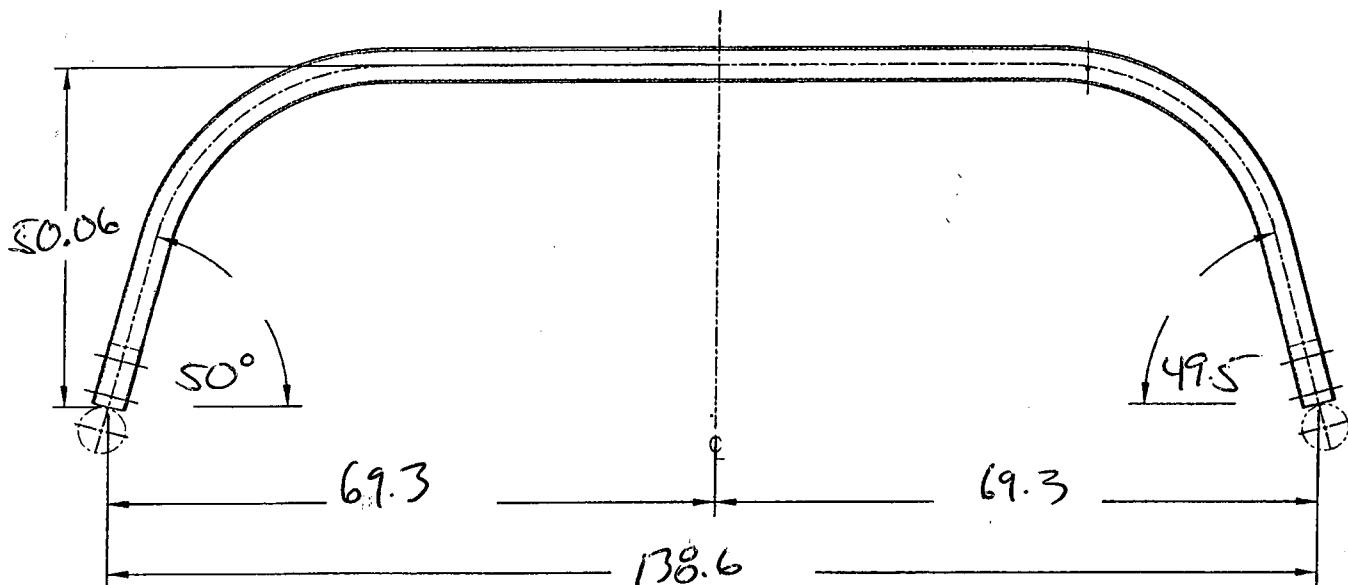
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31367
Description: Crosstube Fwd	Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1

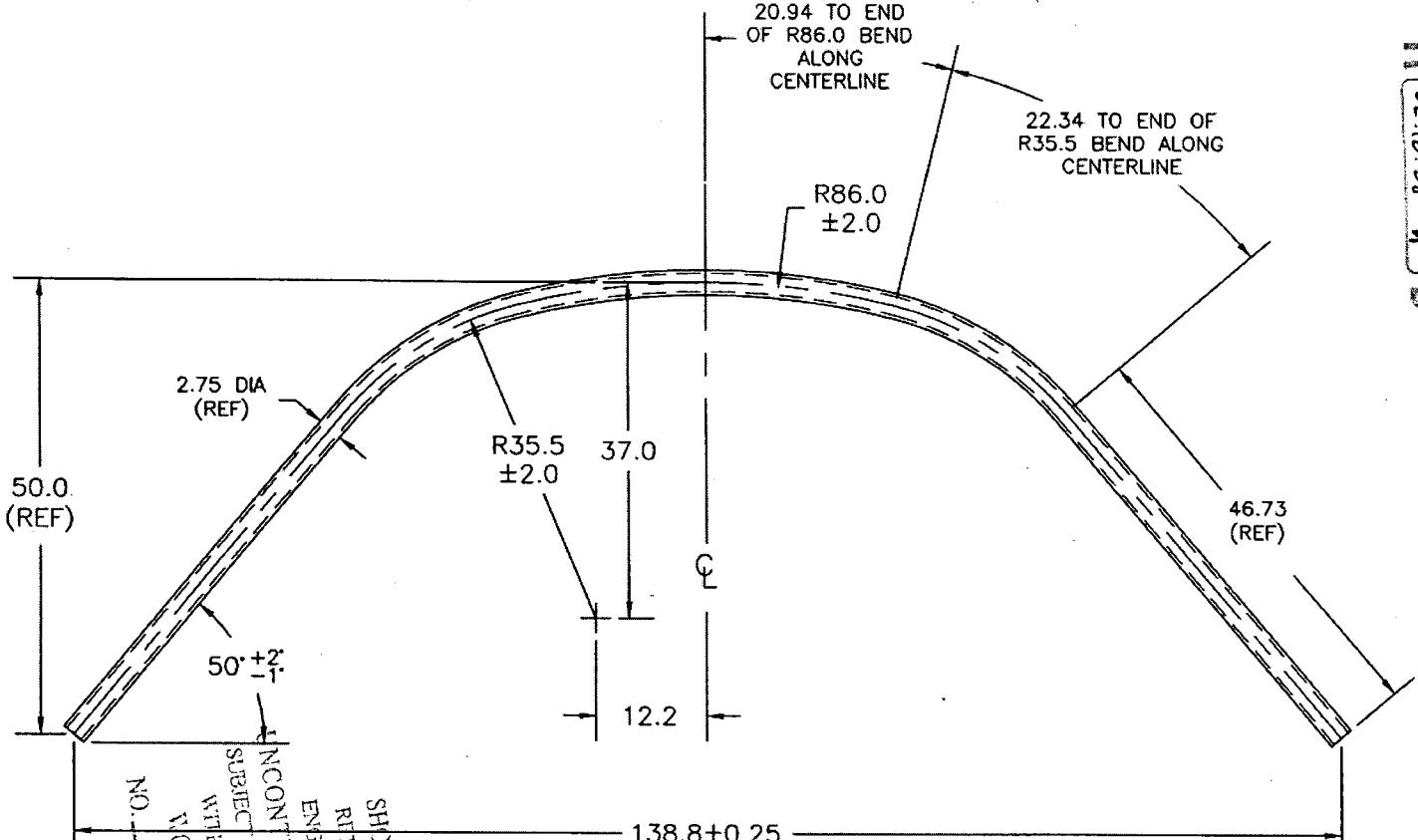
Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
This tube is going for WO 31377 D205-S96-105

QC15 Inspection	<i>[Signature]</i>
Date	07.05.28

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>



**RELEASED**  
02.10.28



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. B
H	H	D2889	SHEET 1 OF 1
DATE			SCALE
02.10.18			1:20
A	99.05.21	NEW ISSUE	
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	

SHIP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31367

#### NOTES

- MATERIAL: MANUFACTURE FROM D6005-180 ( $\varnothing 2.75$  OD x 0.375 WALL)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- PART IS SYMMETRIC ABOUT CENTERLINE
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.